



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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C3-8-2-1
Job Sheet 182826



Part No: C3-8-2-1

Job Qty: 10 ea

Part Name: Solenoid



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/4/18

Job Tracking No:

Due Date: 9/4/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG C3-8-2 Rev 3 IPP Rev A 18.04.09 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	9/4/18	9/4/18	0.00	0.00	Start Up Machining-4		
100	Mill Conv	10 pcs	9/4/18	9/4/18	0.50	2.00	Mill Conv 2		
110	QC	10 pcs	9/4/18	9/4/18	0.00	0.00	QC2 Machining-5		
120	QC	10 pcs	9/4/18	9/4/18	0.00	0.00	QC8 Machining-5		
130	Packaging	10 pcs	9/4/18	9/4/18	0.00	0.00	Packaging3-2		
140	QC21-SA	10 Ea	9/4/18	9/4/18	0.00	0.00	QC21		

Part Op 100 - 1-USE C3-8-2-F1 FIXTURE FOR DRILLING THE PIN HOLE. 2-REMOVE COIL SPRING BEFORE DRILLING
Descriptions: HOLE. 3-TURN SHAFT AS SHOWN IN FIXTURE BEFORE DRILLING (CLOCKWISE). 4-Engrave S/N and/or P/N
number using Marktronic engraver as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
152951-001	Solenoid	10 Ea (1 ea)	90-Start up Operation	5088463

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	152951-001	10	41	0

Part Specifications

Specifications could not be found.



Dart Aerospace Ltd.
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Hawkesbury, ON K6A 1K7
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Email: sales@dartaero.com
www.dartaerospace.com

Plex 9/4/18 9:02 AM dart.logan.david

Container No: S110914



Part: C3-8-2-1

Job No: 182826

Serial No/Batch: S110914

Revision:

Inspector:

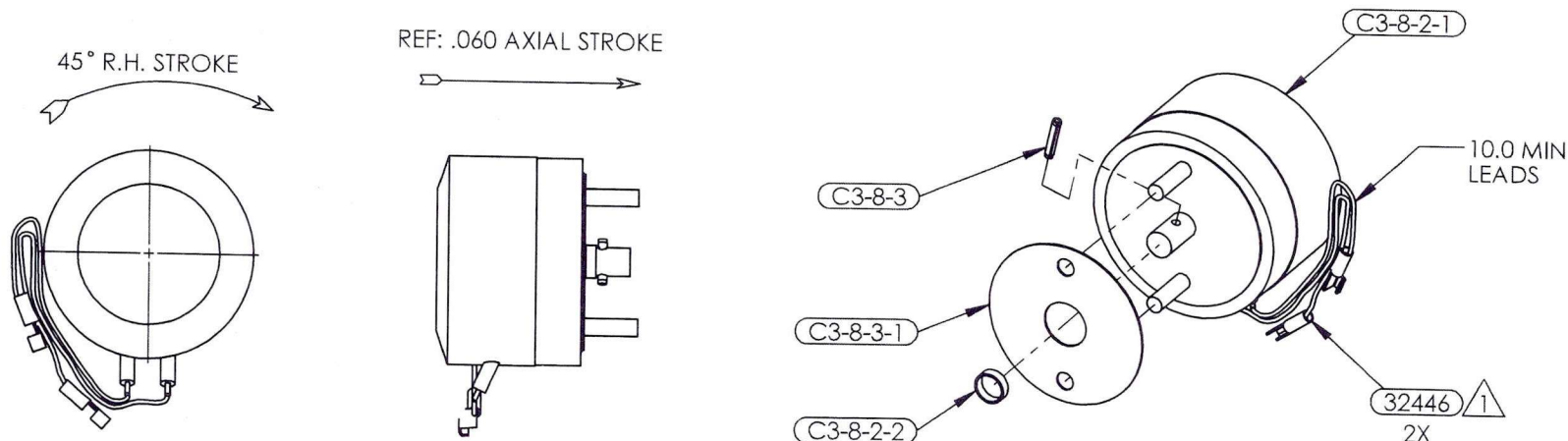
Exp Date:

Instructions:

Date: 09/17/18

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		ADDED SPACER C3-8-31.	10/10/2012	RJC	DW
1A	14-0111	CH'D TITLE BLOCK WAS RED BARN IS DART. ADDED ENGRAVE NOTE. ADDED NOTE	8/7/2014	DJN	RW
2	14-0195	C3-8-2-1 CH'D DIM WAS LIMITS Ø.0933-.0937 IS LIMITS Ø.094-.097. ADDED "(CLOCKWISE)" TO NOTE 3. CH'D NOTE 4 WAS PLACE BUSHING AND PIN IN PLACE AS SHOWN AFTER DRILLING IS INSTALL SPACER AND PIN IN PLACE AS SHOWN ON SHEET 1. AFTER DRILLING. ADDED ENGRAVE BATCH NUMBER NOTE. C3-8-3-1 CH'D DIM WAS Ø2.285 IS Ø1.95. CH'D TOLERANCE ON NON-CRITICAL DIMENSIONS.	10/23/2014	DPD	JAG
3	15-0243	UPDATED TO NEW DRAFTING STANDARDS. C3-8-3-2 DELETED; REPLACED WITH 32446.	8/25/2015	DPD	JAG



SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 179131 MJS
1806-44

NOTE:

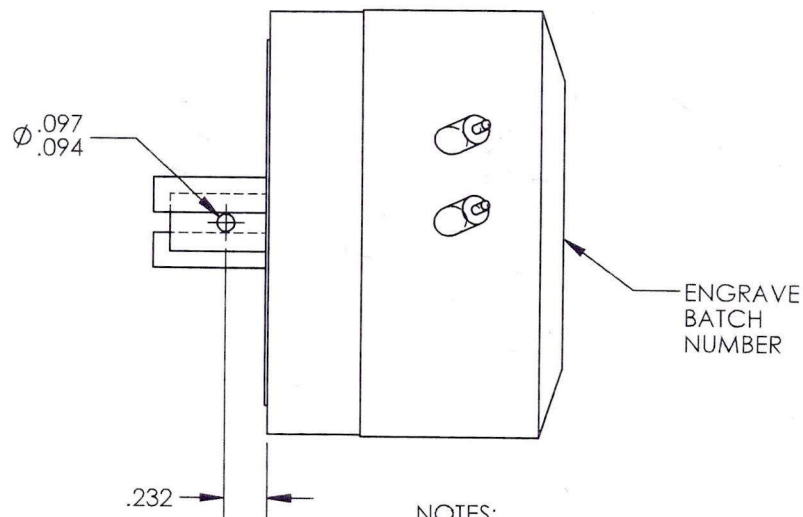
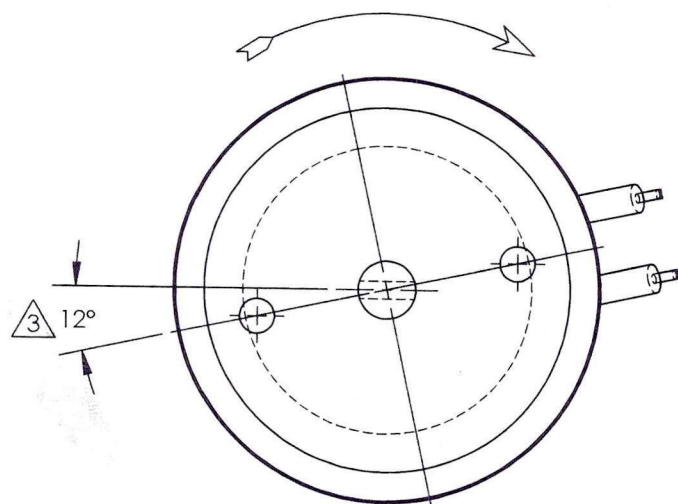
1 CONNECTIONS SUPPLIED LOOSE.

DART AEROSPACE	
TITLE SOLENOID ASSEMBLY	
DWG NO. C3-8-2	REV 3
DRAWN BY: CANAM	
APPROVED	
HEAT TREAT FINISH	
SPEC	
USED ON MODEL	
SCALE 1:2 DATE 12/19/2001 SHEET 1 OF 4	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
		B/O	C3-8-2-1	1	SOLENOID		TESTCO #152951-001	1,2
			C3-8-2-2	1	SOLENOID PIN SPACER	303 S.S.		3
		B/O	C3-8-3	1	SPRING PIN	18-8 S.S.	Ø3/32 X 1/2 (MCMaster-CARR #92373A143)	1
		B/O	C3-8-3-1	1	SPACER	PETG		4
		B/O	32446	2	22-16 AWG KNIFE CONNECTOR		(ALLIED ELECTRONICS 32446)	1

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				JAG



NOTES:

1. USE C3-8-2-F1 FIXTURE FOR DRILLING THE PIN HOLE.
2. REMOVE COIL SPRING BEFORE DRILLING HOLE.
3. TURN SHAFT AS SHOWN IN FIXTURE BEFORE DRILLING (CLOCKWISE).
4. INSTALL SPACER AND PIN IN PLACE AS SHOWN ON SHEET 1 AFTER DRILLING.

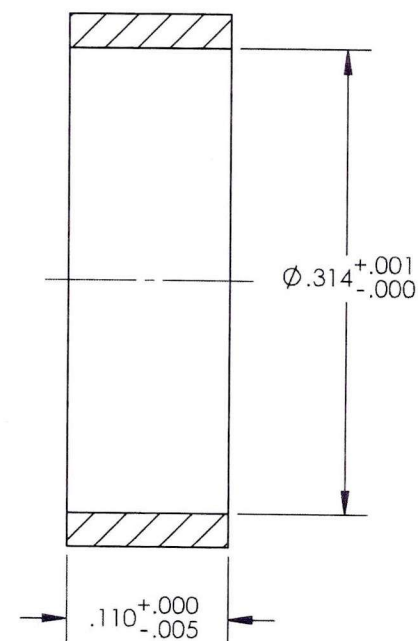
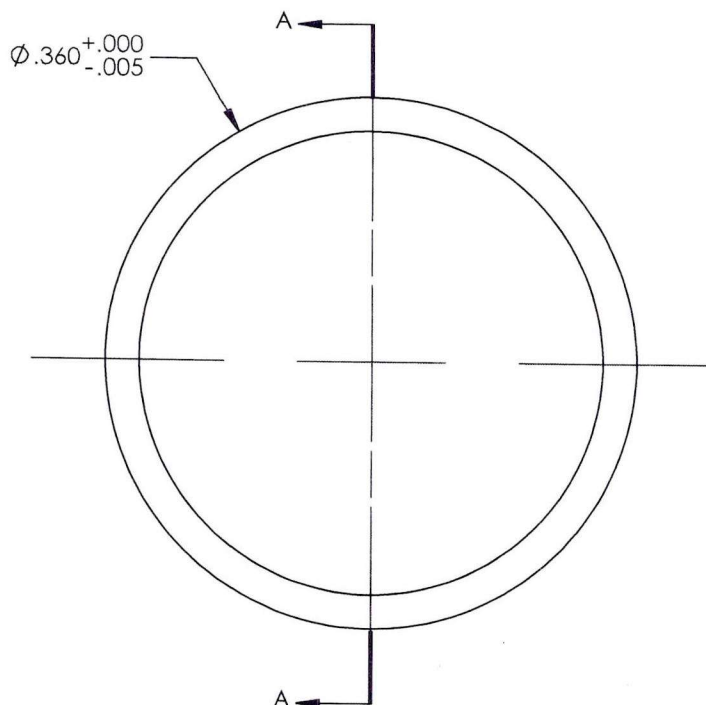
(C3-8-2-1)

SOLENOID WITH PINNED HOLE

DART AEROSPACE	
TITLE SOLENOID ASSEMBLY	
DWG NO. C3-8-2	REV 3
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX $\pm .005$.XX $\pm .01$.X $\pm .1$	DRAWN BY: CANAM APPROVED: <i>D Weil</i> HEAT TREAT FINISH SPEC 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING
SCALE 1:1	DATE 12/19/2001
SHEET 2 OF 4	

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REVISIONS			
REV	ECR	DESCRIPTION	DATE



SECTION A-A

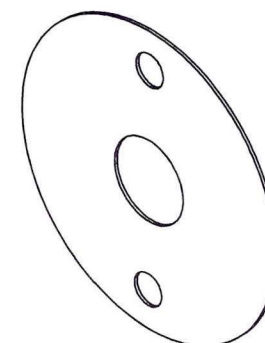
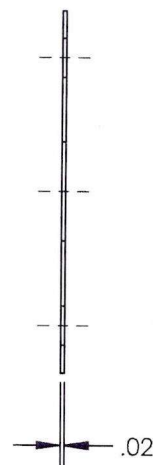
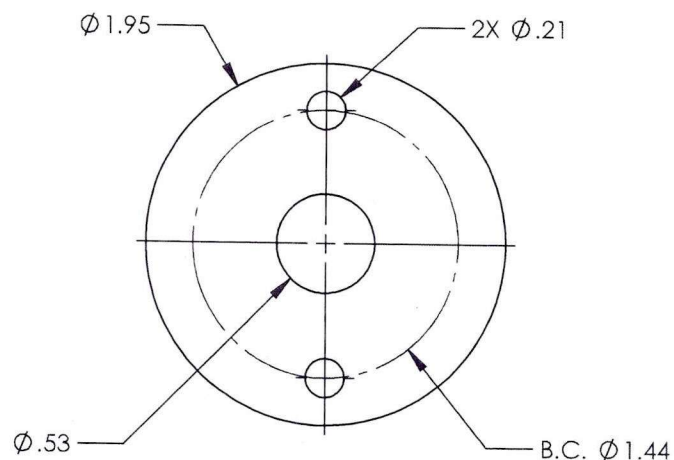
C3-8-2-2

SPACER

DART AEROSPACE	
TITLE SOLENOID ASSEMBLY	
DWG NO. C3-8-2	REV 3
MAT'L 303 S.S.	DRAWN BY: CANAM
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005 FRACTIONS ± 1/8	HEAT
.XX ± .01 ANGLES ± .5°	TREAT
.X ± .1	FINISH
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
SCALE 8:1	DATE 10/31/2001
SHEET 3 OF 4	

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REVISIONS				
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1		ADDED SPACER C-3-8-3-1	10/10/2012	RJC
2	14-0195	C3-8-3-1 CH'D DIM WAS Ø2.285 IS Ø1.95.	10/23/2014	DPD



C3-8-3-1

SPACER

DART AEROSPACE	
TITLE SOLENOID ASSEMBLY	
DWG NO. C3-8-2	REV 3
MAT'L PETG	DRAWN BY: <i>D. Weil</i>
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED
.XXX $\pm$.010 FRACTIONS $\pm$ 1/8	HEAT
.XX $\pm$.03 ANGLES $\pm$ 5°	TREAT
.X $\pm$.1	FINISH
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
SCALE 1:1	DATE
SHEET 4 OF 4	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE**DART**
AEROSPACE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					